

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 31398  
Estimate Number : 12788  
P.O. Number : *N/A*  
This Issue : 3/21/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : SMALL /MED FAB  
Previous Run : 31347  
Written By :  
Checked & Approved By : *[Signature]* 07.03.21  
Comment : Est Rev. A New Issue 07-03-08 e

Drawing Name : WEARSHOE

Part Number : D356413

Drawing Number : D3564 REV A

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 3/30/2007 Qty: 10 Um: Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10. - M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1785 sf(s)/Unit Total: 1.7850 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: M101873

5A) 02/03/24 (10)

20	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAW 07/03/25 (10)

5AD 07/03/24 (10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/03/24 (10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.03.24 (0)

5:0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT

MF 07-03-30

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 1:59:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31398

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Ensure joggle as per dwg D3429

*J070402*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m101601*

*SL*

*07/04/03*

*(10)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*CP 07/04/04 (10)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*CP 07/04/04 (10)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/04/05*

*(10)*

Job Completion



*u st-afaf*

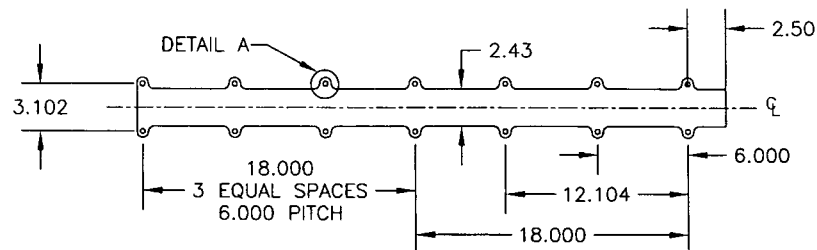
W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

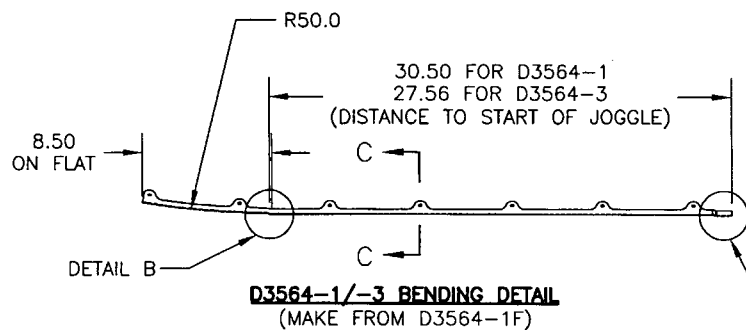
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

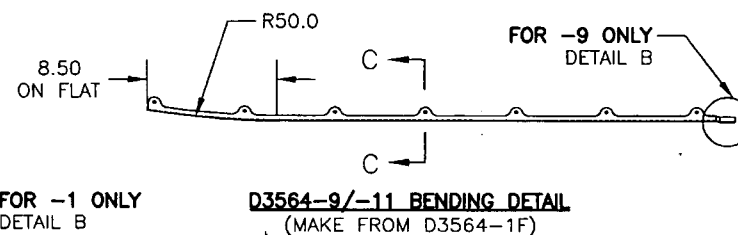
**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**



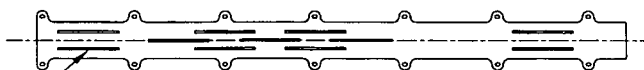
**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

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WITHOUT NOTICE  
WORK ORDER  
NO. **31398**

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

RELEASED

07.07.28

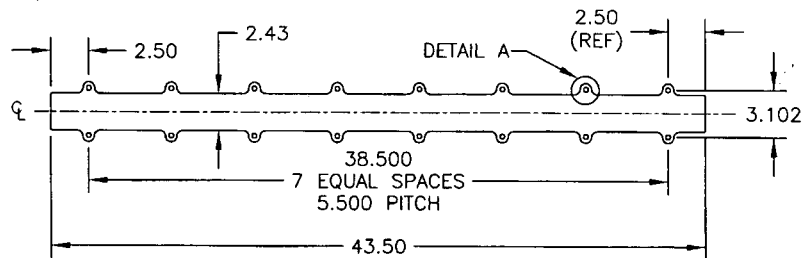
**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

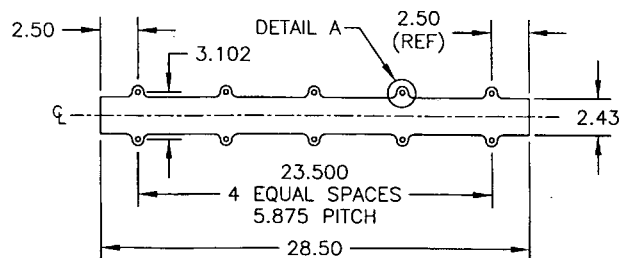
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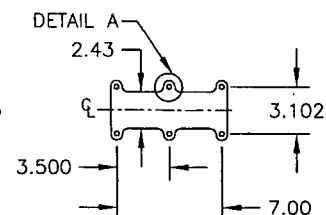
A	06.12.18	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D3564
DATE 06.12.18	TITLE WEARSHOE	REV. A SHEET 1 OF 2 SCALE 1:8



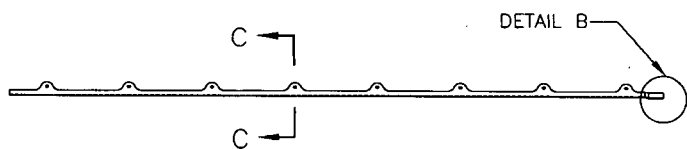
**D3564-5F FLAT PATTERN**



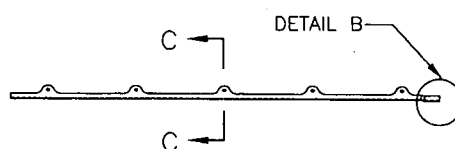
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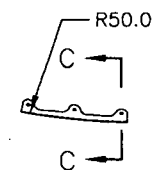
**D3564-13F FLAT PATTERN**



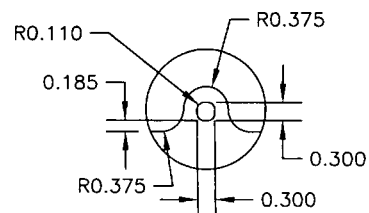
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



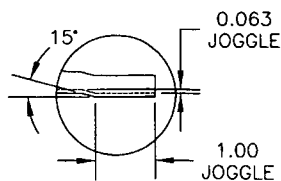
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



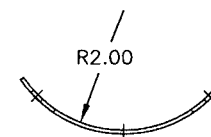
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

RELEASED  
07.02.28

NO. 31398  
WORK ORDER  
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DESIGN RH	DRAWN BY RH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3564	REV. A SHEET 2 OF 2
DATE 06.12.18	TITLE WEARSHOE	SCALE 1:8	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31398
<b>Description:</b>		<b>Part Number:</b> D356413
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.43	+/-0.010	2.428	✓		Veru	
B	3.500	+/-0.030	3.495	✓		Veru	
C	7.000	+/-0.010	7.004	✓		Veru	
D	3.102	+/-0.010	3.102	✓		Veru	
E	0.300	+/-0.010	0.306	✓		Veru	
F	0.300	+/-0.010	0.302	✓		Veru	
G	R0.375	+/-0.010	R0.375	✓		R-G	
H	R0.110	+/-0.010	R0.110	✓		R-G	
I	0.063	+/-0.010	0.059	✓		Veru	
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> SAD	<b>Audited by:</b> SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/24	<b>Date:</b> 07/03/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	